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"HOOPING UP" - MAKING CASKS AND BARRELS.

The oak tree renders the most preferable wood for barrel making.

"No barrel can be longer than its log". These are cut into desired lengths.

A barrel is a "chunk of air" all bound 'round with staves and hoops. Splitting the logs for staves.

Staves are "given the air" for seven months in which they dry. Then they dry in a kiln for two weeks, after which they are shipped.

A barrel has flat ends for heads. These are made just like the staves.

Staves are given their final preparation in the factory, planed and beveled.

"Hooping 'em up".

The steam box get the barrel used to moisture.

No sooner out of the steam room than the barrel is dried.

Often staves are broken.

Large bands hold the barrel in shape much better than any corset add guarantees to do.

Creating the well known bunghole.

Putting a head on each end of the barrel.

Off come the iron bands, the barrel is planed and steel hoops adjusted.

Making steel hoops.

The inside of the barrel is glued and the outside painted by machinery.

Nine months have elapsed since the oak tree was felled. Here, at last, is the finished product.

And now loaded with various American products the barrels start for all corners of the globe to develop our commerce.

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